

Date: Tuesday, 03/02/2009 3:26:52 PM
User: Linda Lacelle

HA ONLY
Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPLATE |
| Job Number : 45479 | |
| Estimate Number : 13459 | |
| P.O. Number : | Part Number : D38051 |
| This Issue : 03/02/2009 S.O. No. : | Drawing Number : D3805 PROTO |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : R & D SM/MED FAB | Drawing Revision : PROTO |
| Previous Run : 05055 | Material : |
| Written By : | Due Date : 06/02/2009 Qty: 1 Um: Each |
| Checked & Approved By : | |
| Comment : Est Rev:A 08-07-15 new issue DD verified by:EC Est Rev:B 08-07-30 redesign flat pattern DD verified by:EC Est Rev:C 08-09-23 redesign flat pattern DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S18GA | 304/316 .050 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 4.0469 sf(s)/Unit Total : 4.0469 sf(s)
304/316 .050 Sheet
batch: *108156* *HB 9-2-4*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3805
Dwg Rev: *PROTO*
Prog Rev: *TYPE*

HB 9-2-4



2-Deburr if necessary *HB 9-2-4*

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

N/A

| | | |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE
Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 09/02/05 *(1)*

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 45479

Part Number: D38051

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC21

FINAL INSPECTION/W/O RELEASE



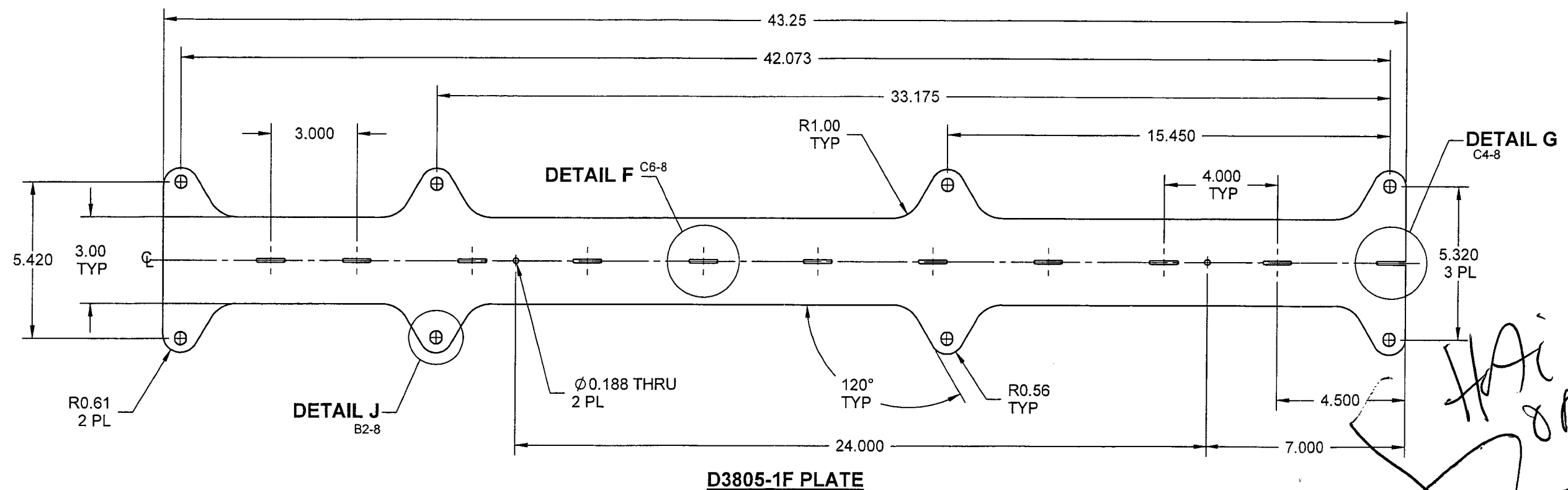
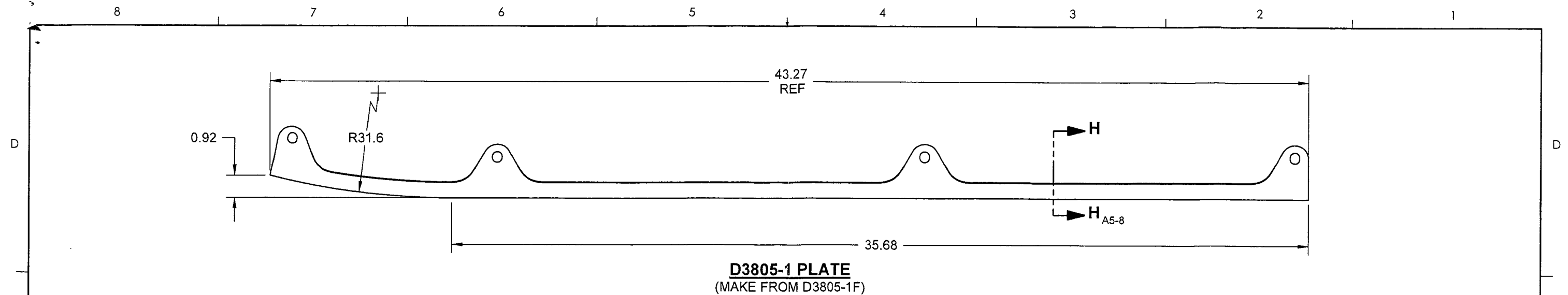
HAI ONLY
NOT FOR SALE OR STOCK

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



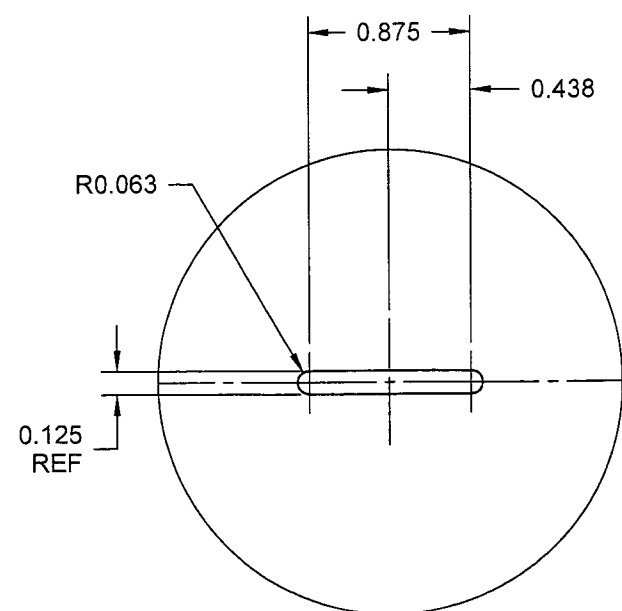
MF
09-02-04
#00600



NOTES:

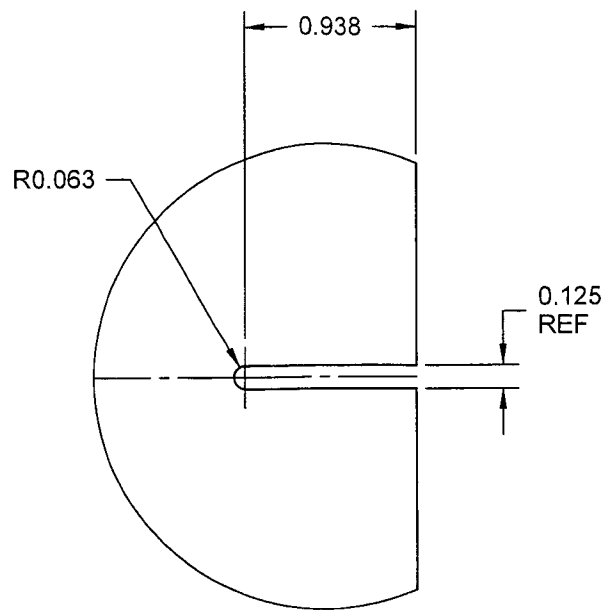
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.11 lbs

| | | | |
|------------|--------------------|---|--------------|
| DESIGN | <i>GP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWN | <i>[Signature]</i> | | |
| CHECKED | <i>AJS</i> | DRAWING NO. | REV. A |
| MFG. APPR. | <i>[Signature]</i> | D3805 | SHEET 4 OF 8 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | WEARPLATE ASSY | NTS |
| DATE | 08.11.21 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |



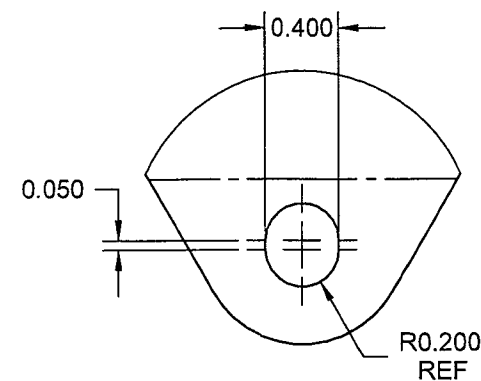
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



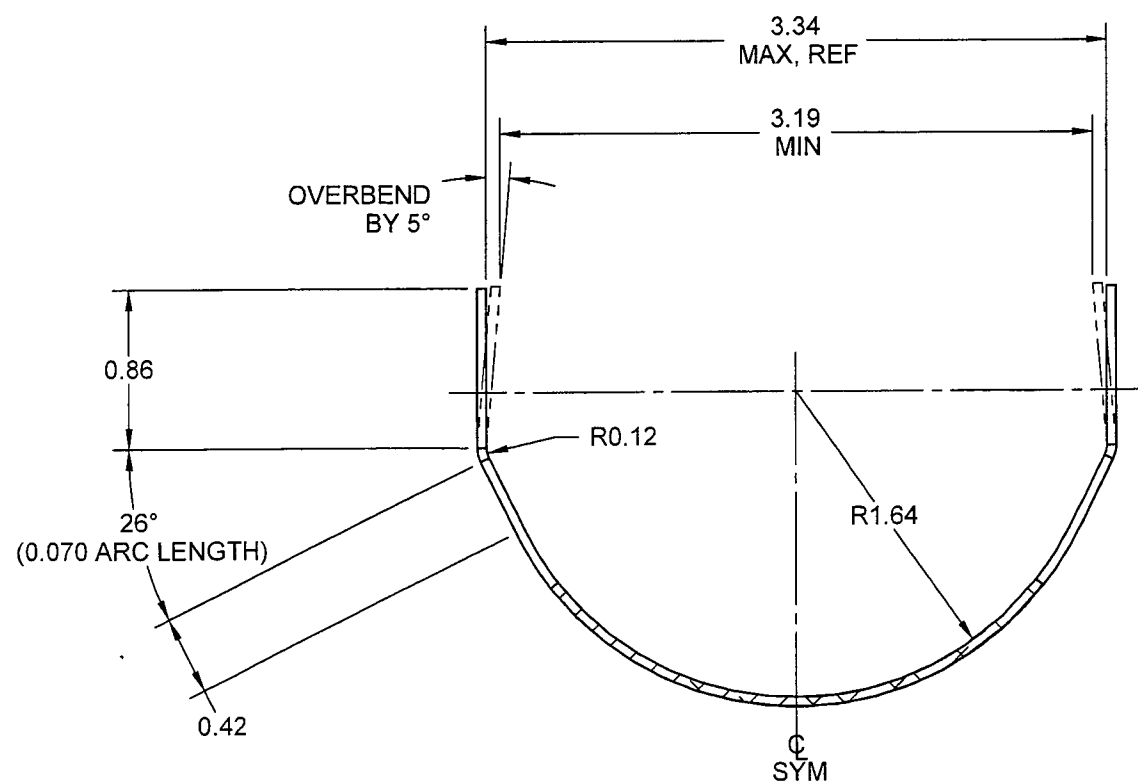
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

PRELIMINARY ISSUE
06.02.03

| | | | |
|------------|----------|---|--------------|
| DESIGN | 190 | DART AEROSPACE USA, INC. | |
| DRAWN | 13 | PORT HADLOCK, WA | |
| CHECKED | 155 | DRAWING NO. | REV. A |
| MFG. APPR. | 155 | D3805 | SHEET 8 OF 8 |
| APPROVED | 190 | TITLE | SCALE |
| DE APPR. | 155 | WEARPLATE ASSY | NTS |
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